Work Orde				*77()43*						Page 1
Item ID: Revision ID: Item Name:	D3455-1 Spacer		1	Accept	*N900	<u>040</u>	100)* ፡	Setup S	I VI	S1* S2*
	25/11/2011	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item II Customer:	D:				· IN	5/"
Approvals:		in: M.L.J	Date: \\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\			nte:	· 	I		tart *N	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	t Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D3455	Rev	A									
*100 *100 Hardinge *Hardinge CNC Lather	e Small	Hardinge CNC LATHE Memo HARDHIN FOLIO RE	GE COBRA1-TURN AS PEI V:DWG REV:	0.00		6		30		ı	
*110 *110* QC Quality Control		QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00 0.00 A) 1/12/0b			30	<u> </u>		· · · · · · · · · · · · · · · · · · ·
120 *120* OC		QC8- Inspect parts - sec	ond check	0.00	11/12/6			30)			

Quality Control

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	INGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										
								<u> </u>		
Part No	:	PAR #:	Fault Cate	gory:	_ NCR:	Yes	No DQ	A:	_ Date: _	
	R	esolution:	Disposition	n:	QA: N	VC CIO	sed:		Date: _	
NCR:		·	WORK ORD	ER NON-CONFORMA	ANCE (NCR)			
DATE	CTED	Description of NC			ion B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
	<u> </u>									
l			1 1		1		- 1			i

Work Orde				*77	043	*							Page 2
Revision ID: Item Name:	D3455-1 Spacer 25/11/2011 09/12/2011	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*	Accept	(ISONO Cust Item I		100)* s	Setup S	tart 🛪	NS NS	S1* S2*
Approvals:		nn:	Date:	Tooling: SPC (Y/N):			ate:		F		tart 4	NF NF	R1* R2*
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab)	Operation Description Small Fab Memo Deburr if nec	cessary.	Set Up/ Run Hours 0.00		Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty			Insp. Stamp
*140 *140 * QC Quality Control		QC5- Inspect part comple	eteness to step on W/O	0.00	ul(Z)	<i>07</i> -							<u></u> -
150 *150* Packaging Packaging		Identify as per dwg & Sto	ock Location: <u>J5</u> Y	0.00				/	[cu/[:	1/2	- <u>-</u>		

W/O:			WC	RK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA :	Date: _	
		esolution:		-				
NCR:		,	WORK ORDI	ER NON-CONFORMA	ANCE (NCF	2)		
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
						;		
	1		1			1	1	1

Work Orde				*77(143*							Page 3
Item ID: Revision ID: Item Name:	D3455-1 Spacer			Accept	*N900	040	100)*	Setup	Start Stop	i VI	S1* S2*
Start Date: Required Date: Reference:	25/11/2011 09/12/2011	Start Qty: 24.00 Req'd Qty: 24.00	*24* *24*		Cust Item I Customer:	D:						
Approvals:	Process Pla	ın:	Date:	Tooling:	D:	ate:			Run	Start	17	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	-	Reject Number	Insp. Stamp
160		QC21- Final Inspection -	Work Order Release	0.00							. /	
160 QC Quality Control		Memo		0.00							11/12	179
											√h,	NF 120

		<u> </u>								
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									į	
			1							
Part No	:	PAR #:	Fault Cate	gory:	NCR	Yes I	No DQA	\:	_ Date: _	
	R	esolution:	Dispositio	n:	_ QA: I	WC Clo	sed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE	(NCR				
DATE	OTED	Description of NC	Corrective Action Section B				Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
	į									
								i		
		·								
								· · ·		
								-		
								-		
				•						
1	1	1	1		1		,		1	

Picklist Print

November-25-11 8:28:51 AM

Work Order ID: 77043

77043

Parent Item:

D3455-1

D3455-1

Parent Item Name:

Spacer

Start Date: 25/11/2011

Qty per Kit Total

Required Date: 09/12/2011

Date

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP REV. A 05.11.17 **NEW ISSUE**

EC

Component Item ID/	
Item Name	

Replacement Mfg/ Item ID Purch Bin Primary Item Location Location

Route Seq ID Unit of Qty on Measure Hand

**

Qty

Qty Issued Status

MDELRINR1.000

Purchased

No

100

67.9995

0.022

0.555789

Last

Issued

Page 1

MDFI RINR1 000

Delrin Round Bar 1"

Location MAT055

117985

119306

67.9995 0.407 9.102 10.4905 48

Loc Qty

Loc Code

.8 An/12/06

W/O:			W	ORK ORDER CHANG	SES					· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·									
Part No	:	PAR #:	Fault Cat	egory:	 NCR: Y	es N	o DQ /	A:	Date:	
		solution:								
NCR:			WORK ORE	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			tion B		Verific	ation	Approval	Approval
DAIE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ın & ate	Section		Chief Eng	QC Inspector
		,								
						:				
									:	

DART AEROSPACE LTD	Work Order:	77043
Description: Spacer	Part Number:	D3455-1
Inspection Dwg: D3455 Rev: A		Page 1 of 1

pe							
Drawing Actual Prototype Method of							
ethod of spection Co	omments						
AZG Vern	······································						
01							
c f							
	16						
	— ·						
ototype Approval:	N/A						
Date:	N/A						
Revised by KJ/JLM ♂	Approved						
	AZB Vern						

	•									
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Da	ate Q	ty ci	oproval nief Eng / Prod Mgr	Approval QC Inspector
										
Dowt No.						<u></u>				
Part No		PAR #:								
	He	esolution:					a:		Date:	
NCR:				ER NON-CONFORM <i>A</i>	NCE (NC	;R) 				
DATE	STEP	Description of NC		on B	\	Verificatio	on Ar	Approval	Approval	
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Da		Section C	Ċ	hief Eng	QC Inspector



DESIGI R		DRAWN BY	DART AERO HAWKESBURY, C	SPACE LTD DITARIO, CANADA
CHECK	#	APPROVED	D3455	REV. A SHEET 1 OF 1
DATE	05.0	9.02	TITLE SPACER	SCALE 2:1
Α	0	5.09.02	NEW ISSUE	

RELEASED 05.12.09

> $\phi A_{-0.000}^{+0.005}$ ØB

RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 77043MC.J 11/11/25 - C

SHOP COPY

1) SPECIFICATION: D3455-X SPACER

DASH No.

D3455-X

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)		
-1	0.453	1.00	0.065		
-3	0.386	1.00	0.050		

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Da	ırt	Aer	OS	nac	90	Ltd
		,,,,,	~~	~~		

W/O:	<u> </u>			W	ORK ORDER CHAN	NGES				
DATE	STEP	PROCEDURE CHANGE				Ву	Date G	Approva Chief Eng / Prod Mgr	Approval QC Inspector	
								•.	:	
Part No	:		PAR #:	Fault Cat	egory:	NCI	R: Yes	No, DQA:_	Date:	
Resolution: Dispos			Dispositi	on:	• •					
NCR:				WORK ORI	DER NON-CONFOR	MANCE	(NCR)		
DATE STE	STED	Desc	Description of NC Section A	Corrective Action Section			Cian 9	Verificati		
	SIEP			Initial Chief Eng	Action Descriptio	on	Sign & Date	Section C	Chief Eng	QC Inspector
								;		
·			<u> </u>							
		1						i		

[·] HalfFORMS\Quality Assurance\approved QA\NCRWO RevE